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TAMPER EVIDENT CLOSURE

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(57) Claim

19. A tamper evident closure suitable for mounting onto a container having closure retention means on the neck of the container, said closure comprising a top portion, a skirt portion depending from the top portion, and a tamper evident band portion extending from the skirt portion by connection through frangible bridges, the band comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to provide a lip having an inner free edge to engage under a retaining flange extending outwardly from the neck of the container below the closure retention means thereon, characterised in that the combined length of the segmented ribs being equal to at least 50% of the internal circumference of the band and the segmented ribs being separated from each other by a gap, the rib segments each having an upper side facing generally towards the top portion of the closure and an under side facing generally away from the top portion, the inner surface of the band having a plurality of radially inward projections extending from above the free edge of band and not extending beyond the inner free edge of the lip.

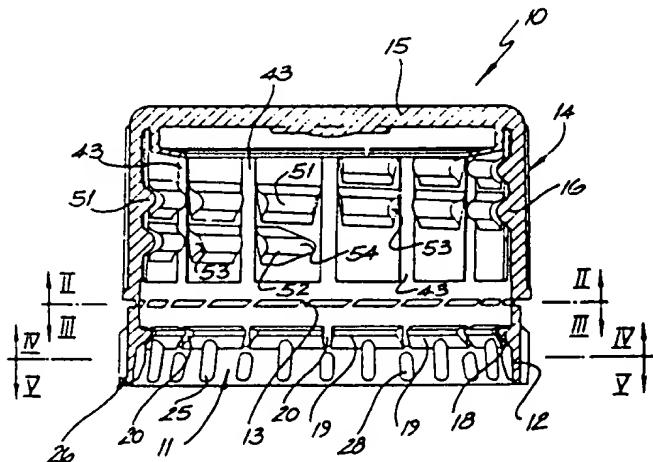


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(54) Title: TAMPER EVIDENT CLOSURE



(57) Abstract

A container closer (10) particularly for use on screw top containers such as carbonated beverage containers, the container closure (10) having a generally cylindrical continuous tamper evident band (11) joined by a plurality of frangible bridges (13) to the free edge of a skirt (16) of the closure (10). The band (11) has a segmented internal rib (18) which engages an external retaining flange of the container when the closure (10) is applied to the container so that on removal of the closure (10) the tamper evident band (11) remains on the container or is visually clearly damaged by removal of the closure (10) from the container. The band (11) is provided with longitudinal reinforcement by projections (25 and 28) or other areas of thickening (26) to provide the band (11) with longitudinal stiffness while still permitting it to expand over the retaining flange on the container. The rib (18) has a first annular side (21), the first annular side (21) having a compound surface comprising a radially outer frusto-conical portion (23) which assists in the molding of the rib (18) and a radially inner substantially planar portion (24) which increases the difficulty of removing the closure (10) intact from the container without rupturing the bridges joining the tamper evident band (11) from the remainder of the closure (10).



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TAMPER EVIDENT CLOSURE

Field of the Invention

The present invention relates to closures for containers having an externally screw threaded neck and more particularly to such closures which are formed with a 5 tamper evident band.

Background Art

Manufacturers of foodstuffs, beverages, medicaments, dentifrice and the like are concerned to ensure that products they place on the market are not tampered with 10 before being opened by the ultimate consumer of the goods. For this purpose it has become conventional to include in closures for such goods means which will indicate whether the closure has been tampered with before purchase. In the case of containers having an externally 15 screw threaded neck it is common to provide the closure with a tamper evident band which engages behind a retaining flange formed on the neck of the container. The tamper evident band is joined to a depending skirt forming part of the closure by a number of frangible bridges. On 20 application of the closure to the container the band is forced over the retaining flange, however, when the closure is unscrewed from the container the bridges are sheared as the band is trapped behind the retaining flange while the closure moves up the neck of the container.

25 While such tamper evident bands have been widely accepted there is a delicate balance between the two conflicting requirements. On the one hand, one must be able to apply the closures to containers at very high speed without inadvertently breaking the bridges, or 30 breaking or deforming the band itself, or deleteriously affecting the seal between the closure and the container. On the other hand, the band must be sufficiently tightly secured behind the retaining flange and the bridges and/or the band must be sufficiently easily broken that the 35 closure cannot be removed from the container without

rupturing the bridges and/or the band.

Another problem is that an unauthorized person might attempt to remove the closure and tamper evident band, without damaging the band or frangible bridges, in order to contaminate or replace the container contents

5 and then reapply the closure. Such operation might be attempted with the assistance of a thin device, such as a knife blade, wedged up between the tamper evident band and the neck of the container to which the closure has been applied. The device might then be levered outwardly in order to expand the inner diameter of the band so that it may be passed back over the

10 retaining flange of the container. In such a process the device will be edged around the circumference of the band so as to gradually ease the band over the retaining flange at a continuously lengthening portion of the band circumference.

Closures of the type mentioned above are used around the world in

15 extremely large numbers. To be commercially acceptable such closures must be capable of being produced very rapidly in automated machinery. This itself may produce a conflict with the functionality of the closure and/or its tamper evident band.

The arrangement according to the present invention is designed to

20 provide the public with an alternative form of closure having a tamper evident band.

#### Disclosure of the Invention

The present invention in its broadest aspect comprises a closure for a container having closure retention means on its neck, the closure comprising

25 a top portion and a depending skirt which has on its interal surface a complementary closure retention means, a free edge of the depending skirt being joined by a plurality of frangible bridges to a tamper evident band, the band comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to



provide a lip to engage under a retaining flange extending outwardly from the neck of the container below the closure 5 retention means thereon, the rib having an upper side facing generally towards the top of the closure and an under side facing generally away from the top, the body portion being provided with projections or other localised areas of thickening to enhance the longitudinal stiffness of the body portion while still permitting it to expand 10 radially as it is forced over the retaining flange on a container.

In a first preferred aspect the present invention consists in a closure for a container having an externally 15 screw threaded neck, the closure comprising a top and a depending skirt which has on its internal surface a complementary screw thread, a free edge of the depending skirt being joined by a plurality of frangible bridges to a tamper evident band, the band comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to provide a lip 20 to engage under a retaining flange extending outwardly from the neck of the container below the screw thread thereon, the rib having an upper side facing generally towards the top of the closure and an under side facing generally away from the top, the closure being 25 characterized in that the upper side of the rib comprises a first surface contiguous with the body portion of the band, which surface slopes inwardly and downwardly from the top, and a second surface which is positioned radially inwardly from the first surface, the second surface having 30 a slope angle more nearly normal to the longitudinal axis of the closure than the first surface is to that longitudinal axis.

In the prior art closures the upper side of the rib has always been linear in cross-section. The upper side 35 has either lain in a plane normal to the longitudinal axis of the closure or it has been a simple frusto-conical



surface inclined to that axis. In the former case it has been difficult to mold as the upper side is normal to the direction in which the core of the mold must be withdrawn from the cap. In the latter case there is more likelihood of the rib being able to be forced upwardly over the flange on the container neck. The present invention has resolved these problems by providing the upper side of the rib with a compound surface having a more steeply angled radially outer surface which assists molding of the rib and, preferably, a substantially planar radially inner surface normal to the longitudinal axis of the closure which increases the difficulty of removing the closure intact from a container. There is preferably a relatively clearly defined junction between the first and second 10 surfaces on the upper side of the rib. However, they may merge together gradually such that the upper side of the rib is generally arcuate in cross-section. It has been found that improved resistance to removal of the closure from the container can be obtained in this way while 15 facilitating the molding of the closure. This latter aspect is important as for economic reasons, it is necessary that the closures and their associated tamper 20 evident bands must be capable of being molded at extremely high rates.

25 The first surface on the upper side of the rib preferably comprises from 25% to 75% and more preferably 45% to 55%, of the radial width of the upper side of the rib. The first surface preferably has a slope angle to a plane normal to the longitudinal axis of the closure of from 10° to 60°, more preferably 12° to 40° and most 30 preferably 15° to 25°. The second surface on the upper side of the rib preferably comprises from 75% to 25% and more preferably 55% to 45% of the radial width of the upper side of the rib. The second surface preferably lies 35 in a plane normal to the longitudinal axis of the closure



or at an angle of up to  $10^{\circ}$  to that plane, most preferably it lies in that plane.

In carrying out the present invention it has been found that during the injection moulding of closures from an injection mould which defines a rib having an upper side comprising a first annular surface and a second annular surface the clear distinction between the first and second surfaces may be lost to the naked eye, or at least difficult to discern, in the moulded product. It is thought that this may be due to the second annular surface being distorted and dragged into a slope angle similar to that of the first surface as the closure is ejected from the mould. Despite the anomaly that the mould clearly displays the two surfaces but the moulded closure does not, it has been found that the closures moulded from such a mould show superior resistance to being tampered with as compared to similar closures moulded in a mould not defining the upper side of the rib as having first and second surfaces.

In another aspect the present invention consists in a closure for a container having an externally screw threaded neck, the closure comprising a top and a depending skirt which has on its external surface a complimentary screw thread, a free edge of the depending skirt being joined by a plurality of frangible bridges to a tamper evident band, the band comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to provide a lip to engage under a retaining flange extending outwardly from the neck of the container below the screw thread thereon, the rib having an upper side facing generally towards the top of the closure and an under side facing generally away from the top, the closure being characterised in that the closure is formed by injection moulding from a synthetic plastics material in a mould which defines the upper side of the rib as comprising a



first surface contiguous with the body portion of the band, which surface slopes inwardly and downwardly from the top, and a second surface which is positioned radially inwardly from the first surface, the second surface having a slope angle more nearly normal to the longitudinal axis of the closure than the first surface is to that longitudinal axis. The mould surface preferably has the other characteristics previously described as being preferred for the upper side of the rib itself.

In another aspect of the invention the radially inner surface of the band is provided with an array of radially spaced apart inwardly extending projections positioned between the rib and a free edge of the band. The projections, or some of them, may, if desired, make contact with the under side of the rib across the longitudinal width of the band or they may stop short of the lower free edge of the band. They preferably are aligned parallel with the longitudinal axis of the closure but may be inclined to that axis. These inwardly extending projections make it difficult for a person deliberately trying to expand the diameter of the band and to ease it off the neck of the container intact by inserting a blade or other tool between the band and the container.

In a particularly preferred arrangement, the segmented rib has alternate projections disposed beneath the gaps between the rib segments and beneath, most preferably, the mid-points of the underside of the rib segments, said projections abutting the underside of the segments. The projections are preferably inclined radially inwardly as they approach the rib, however they preferably do not extend inwardly from the radially inner surface of the body portion of the band as far as the rib does. The projections preferably extend radially inward so as to not extend beyond the first surface of the upper side of the rib.



The rib formed to engage with the retaining flange on the container while segmented about the band will still extend about a majority of the circumferential extent of the inside surface of the band. The rib segments are 5 preferably evenly spaced about the inside circumference of the band and occupy at least 50%, preferably at least 65% and most preferably at least 80%, of the internal circumference of the band. The rib preferably has a sufficiently broad base where it joins the body portion of 10 the band.

Each of the rib segments is preferably formed with two substantially planar end surfaces which are inclined to the axis of the closure and face away from the closure top, i.e., they face in a direction that a mould core used 15 to mould the closure was withdrawn. The planar end surfaces are also preferably inclined to a notional radial plane extending from the longitudinal axis of the closure to the end of the respective rib segment such that the ends are inclined to the skirt of the closure by an included angle that is less than the included angle that 20 the respective notional plane makes with the skirt.

The tamper evident band is further preferably provided with areas of localised thickening which extend outwardly from an external surface of the body portion of the band. 25 The areas of thickening further preferably extend parallel to the longitudinal axis of the closure and across the longitudinal width of the band.

The areas of outer thickening serve to reinforce and 30 strengthen the tamper evident band. The reinforcement of the band preferably enhances the vertical stiffness of the band whilst retaining a sufficient flexibility to facilitate application of the closure to the container. The reinforcement also allows sufficient axial force to be applied to the free end of the band in order to 35 successfully eject the closure from a core portion of a mould used in the closure production. The reinforcement

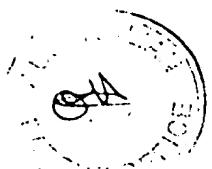


of the band further reduces the possibility of the closure being tampered with and the band stretched in order that it may be eased back over the retaining flange on a container to which the closure has been applied.

5 The bridges are preferably evenly spaced about the circumference of the closure but may be optionally arranged in two groups which are diametrically opposed to one another. Each group may preferably occupy from one quarter to one third of the circumference of the closure  
10 while each of the spaces between the groups occupies from one quarter to one sixth of that circumference. Each group of bridges is preferably made up of from 4 to 10 bridges equally spaced apart within the group.

15 The individual bridges in each group may have an axis parallel to the axis of the closure. Preferably, however, the axis of each bridge is inclined to the axis of the closure, more preferably it is inclined such that when seen in side elevation the upper end of the bridge is inclined to the left relative to its lower end. This  
20 particularly preferred arrangement is predicated by the fact that most screw threads tighten in a clockwise direction. The preferred inclination of the bridges allows them to bend as the closure is screwed onto a container. This stabilizes the band and reduces the  
25 likelihood of it, or the bridges, breaking or distorting during application. Conversely this preferred inclination of the bridges means that as the closure is unscrewed the bridges are straightened out and this serves to concentrate the forces tending to rupture the bridge at  
30 the point of attachment of each bridge to the band and to the skirt.

35 The thread on the internal surface of the skirt of the closure is preferably formed of a series of thread segments arranged, starting from a first thread segment distal to the top, along a helical thread locus. Each of the thread segments, except the first, is preferably



formed with two substantially planar end surfaces which are inclined to the axis of the closure and face away from the closure top, ie, they face in the direction that a mould core used to mould the closure was withdrawn. The 5 term "substantially planar surface" is used to mean a surface which is nearly actually planar or which is curved provided that it all faces in the defined direction. The first of the thread segments is preferably pointed at its end distal to its one adjacent thread segment to assist in 10 mating the thread on the closure with a corresponding thread on the neck of a container.

The substantially planar ends of the thread segments are also preferably inclined to a notional radial planes of the closure extending from the longitudinal axis of the 15 closure to the end of the respective thread segment such that the ends are inclined to the cylindrical skirt by an included angle that is less than the included angle that the respective notional radial plane makes with that skirt.

20 To assist in the venting of gas between the thread segment the spaces between the segment in adjacent turns of the thread are aligned. A groove may be provided on the inside surface of the skirt of the closure extending longitudinally thereof through the aligned spaces.

25 In another embodiment the present invention consists in an injection moulded article including a cylindrical wall having a thread formed on its radially inner surface, the thread being comprised of a plurality of segments arranged in spaced apart array along the helical locus of



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the thread, at least some of the thread segments terminating at at least one end in a substantially planar surface inclined to the axis of the thread and facing the direction in which a mould core used in the moulding of 5 the article was withdrawn.

The closure is preferably formed with means for sealingly engaging with the container to prevent leakage therefrom. Any one of the large number of alternative sealing arrangements known may be used with the closure 10 according to the present invention. These include integral sealing ribs or flanges, wadding or flowed-in gaskets.

The sealing arrangement preferably comprises an annular sealing rib which projects downwardly from an 15 underside of the top of the closure, the rib including a first portion having a substantially cylindrical inner surface, the first portion being contiguous with the top and lying adjacent to the skirt of the closure and a second, frusto-conical, portion 20 contiguous with an end of the first portion distal to the top and extending radially inwardly to terminate in a circular free edge, the first portion having an internal diameter at least equal to an external diameter of the neck of the container to which the closure is to be 25 attached such that during threaded engagement of the closure with the neck, the second, frusto-conical, portion will be engaged by a free end of the neck and folded back against the substantially cylindrical inner surface of the first portion of the rib to form a gas-tight seal between 30 at least an outer surface of the neck of the container and the closure.

The closure most preferably has a skirt having a substantially cylindrical form carrying on its outside surface a series of fine vertical ribs terminating at the 35 lower edge of the skirt in a narrow circumferential rib.

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The frangible bridges are preferably considerably thinner in their radial dimensions than the skirt and the band and the inner surface of the bridges lie flush with the respective radially inner surfaces of the skirt and the 5 band. The radially outer surface of the band is of a slightly smaller diameter than the skirt except in the areas of local thickening which project radially outwardly beyond the radial extent of the skirt.

In this most preferred embodiment of the inside 10 surface of the skirt is preferably generally cylindrical with a helical array of thread segments extending radially inwardly of that surface. The thread segments are separated from one another by axially aligned spaces. The inside of the band is preferably defined by a smooth upper 15 cylindrical surface above the rib of the same diameter as the inside surface of the skirt. The rib is preferably formed of rib segments in axial alignment with the thread segments on the inside surface of the skirt and with the spaces between the rib segments in axial alignment with 20 the spaces between the thread segments. Below the rib the inside surface of the band is inclined downwardly and outwardly so that the band is a little thinner at its lower end than it is at the upper end. This inclined 25 surface carries an array of projections which are axially aligned and of a thickness less than that of the rib segments. Alternate ones of the projections abut at their upper end against the mid point of one of the rib segments, while the other projections are each aligned with one of the spaces between the rib segments.

30 Brief Description of the Drawings

A preferred embodiment of the present invention will now be described with reference to the accompanying drawings in which:-

35 Fig. 1 is a diametric sectional view through one embodiment of the closure according to this invention;

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Fig. 2 is a view along section II-II of the closure of Fig. 1;

Fig. 3 is a view along section III-III of the closure of Fig. 1;

5 Fig. 4 is a view along section IV-IV of the closure of Fig. 1;

Fig. 5 is a view along section V-V of the closure of Fig. 1;

Fig. 6 is a view along section VI-VI of Fig. 4;

10 Fig. 7 is a view along section VII-VII of Fig. 4;

Fig. 8 is a side elevational view of the closure of Fig. 1 seen in the direction of arrow A of Fig. 3;

Fig. 9 is a side elevational view of the closure of Fig. 1 seen in the direction of arrow B of Fig. 3;

15 Fig. 10 is a longitudinal cross-sectional view of another embodiment of the closure on an enlarged scale and shows the closure in relation to a neck of a container, as the closure is screwed onto the container; and

Fig. 11 is a longitudinal cross-sectional view of the 20 closure of Fig. 10 with the closure sealingly engaged with the neck of the container.

Fig. 12 is a vertical sectional view through a part 25 of a mould used for the injection moulding of closures according to the present invention with the area defining the rib being also shown as an enlarged seal.

The tamper evident closure 10 includes a continuous tamper evident band 11 having a generally cylindrical body portion 12 attached by frangible bridges 13 to a cap portion 14 of the closure 10. The cap portion 14, 30 frangible bridges 13 and tamper evident band 11 are formed integrally by injection molding from suitable material such as polyethylene or polypropylene. The cap portion 14 includes a circular top 15 and a depending skirt 16. The inside of the skirt 16 is screw threaded and adapted to be 35 attached to containers commonly made from glass or a

plastics material such as poly(ethylene terephthalate) (PET) which have an externally screw threaded neck.

The container 29 (a portion of which is shown in Figs. 10 and 11) to which the closure 10 will be attached 5 includes a continuous generally annular retaining flange 30 immediately below the screw thread 31 of the container 29 so as to form an outwardly radially directed lip. The band 11 includes a rib 18 about its inside surface being sized and shaped so as to provide an inwardly extending 10 lip which will engage under the retaining flange 30 of the container 29 once the closure 10 is fully closed onto the container 29.

The rib 18 is made up of a series of rib segments 19 separated by short breaks 20 however the rib segments 19 15 constitute about 85% of the circumference of the band and act together as though the rib 18 were substantially continuous. The breaks 20 provide circumferential flexibility to the band and allow the rib 18 to pass over the retaining flange 30 without stress, sufficient to 20 break the frangible bridges.

The rib 18 has an upper side 21 directed towards the top portion 15 and an under side 22 directed away from it. The upper side 21 includes a radially outer frusto-conical surface 23 and a radially inner annular 25 surface 24. The annular surface 24 lies in a plane normal to a longitudinal axis of the closure 10 while the frusto-conical surface 23 is inclined inwardly and downwardly away from the top portion 15 and makes an angle of about 20° with the plane normal to the longitudinal 30 axis of the closure. The outer frusto-conical surface 23 and the inner annular surface 24 each comprise about one half of the radial width of the upper surface of the rib 18. In use it is the annular surface 24 which engages under the flange 30 on the neck of the container 29 to 35 which the closure 10 is attached. The presence of the

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frusto-conical surface 23 assists in the molding of the closure 10 as it prevents or at least substantially reduces the production of closures having deformed ribs 18. It also ensures rigidity of the rib 18 and

5 thereby prevents distortion of the rib 18 as it is forced over the retaining flange 30 as the closure 10 is screwed down onto the container 29. The rib 18 is sufficiently robust that it can, on its own, withstand the forces applied to it during application to the container 29 and

10 also prevents the cap 14 from being removed without breaking the frangible bridges 13 either by normal removal of the cap 14 or due to tampering with the container 29. It has been found that there is no deleterious effect in not having the annular surface 24 extend across the full

15 width of the upper surface 21 of the rib 18.

Below the rib 18, and still on the inside surface of the body portion 12 of the band 11, is an arrangement of a plurality of inwardly extending projections 25 and 28, each having a long axis generally aligned with the

20 longitudinal axis of the closure 10. The projections 25 and 28 extend radially inwardly from the inner surface of the body portion 12 sufficiently to come into contact with the retaining flange 30 during application of the closure 10 to the container 29 and once the container is

25 capped to lie close to the outer neck surface of the container 29. Each alternate inwardly extending projection 28 is spaced below the break 20 in the substantially continuous rib 18 and is not connected to the rib 18. Each of the remaining inwardly extending

30 projections 25 are connected at one end to the centre of a rib portion 19.

The radially inner free edge of each rib segment 19 projects inwardly well beyond the innermost extent of the projections 25 and 28 and must be sufficiently sturdy to

35 be self-supporting during application of the closure 10 to

the container 29 and in preventing the band 11 from riding up over the retaining flange 30.

The projections 25 and 28 prevent a person from introducing a device such as a knife blade radially inwardly of the body portion 12 of the band 11 and progressively moving the device circumferentially around the band 11 in an effort to gradually prise the rib 18 up and over its mating flange 30 on the container 29.

Along the outside surface of the band 11 are a number of reinforcements or thickenings 26. Each thickening 26 extends from a region adjacent the level of rib 18 to a region at the free end of the band 11. The thickenings 26 in conjunction with the inwardly extending projections 25 and 28 strengthen the band 11 and thus enhance the vertical stiffness of the band 11 whilst retaining a sufficient horizontal or radial flexibility. This also allows sufficient axial force to be applied to the free end of the closure 10 to successfully eject the closure 10 from a core portion of a mold used in its production.

The outer surfaces of the thickenings 26 present substantially flat lands 27 which lie radially just outside the radial extent of the rest of the closure 10 to allow the land to be mechanically gripped or otherwise contacted without necessarily contacting the skirt.

The closure 10 is formed with a sealing arrangement which includes a concentric annular rib 32 which extends from the underside of the top portion 15 of the cap portion 14. The annular sealing rib 32 includes a first or root portion 33 which extends downwardly from the top portion 15 approximately parallel to the skirt 16 with a second portion 34 which, prior to engagement with the neck of the container 29, tapers inwardly and away from the skirt 16.

The second portion 34 of the rib 32 contacts the end 35 of the container 29 as the closure 10 is being

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screwed onto the container 29, and the second portion 34 is caused to fold up against the surface of the first portion 33. Thus there is formed a continuous gas tight seal between the closure 10 and the container 29 extending 5 up the side wall 36 of the container 29 to the end 35 of the container 29.

As the closure 10 is screwed onto the neck of the container 29, the second portion 34 of the sealing rib 32 is deformed by being bent towards the top 15. The 10 deformation continues and contact is made between the second portion 34 and an inner rib 37 on the inside surface of the top 15. The inner rib 37 in fact is not essential to the invention and can be dispensed with if desired.

15 Once the second portion 34 has contacted the top portion 15, further movement attaching the closure 10 will press and grip the contacting part of the second portion 34 between the container end 35 and the top portion 15. As the movement attaching the closure 10 continues, it 20 tends to pinch the free edge of rib 32 between the container 29 and the top portion 15 and to "pull" the first portion 33 of the annular rib 32 tightly in towards the container end 35 to produce a tight seal about the curved edge surface of the container 29 extending from its 25 extreme end annular surface 35 down the side wall 36.

As the closure 10 is screwed onto the neck of the container 29, the screw thread 31 also engages the thread 39 on the interior surface of the skirt 16. As the closure 10 moves down the neck of the container 29 the 30 frangible bridges 13 form an annular weak zone which allows the rib 18 to diametrically expand over the retaining flange 30 of the container 29.

In this embodiment the frangible bridges are equally spaced about the circumference of the closure 10 and the 35 axis of each frangible bridge 13 is inclined such that

when seen in side elevation the upper end of each bridge 13 is inclined to the left relative to its lower end. The bridges 13, therefore, bend as the closure 10 is screwed clockwise onto the container 29. As the rib 18

5 expands over the flange 30, the lower edge 42 of the skirt 16 and the upper edge 41 of the band 11 have room to flex towards each other whilst still having the bridges 13 therebetween. This stabilises the band 11 and reduces the likelihood of the bridges 13 breaking during application.

10 Once the rib 18 has passed over and engaged under the flange 30, the frangible bridges 13 return to their extended orientation (Fig. 11). As the closure 10 begins to be unscrewed from the neck of the container 29, the rib 18 detains the band 11 under the flange 30. As the

15 closure 10 is unscrewed further, the bridges 13 are straightened which serves to concentrate the forces tending to rupture the bridges 13 at the point of attachment of each bridge 13 to the band 11 and to the skirt 16.

20 As is best seen in Fig. 1, inside the skirt 16 is a thread made up of a plurality of thread segments 51 arranged in spaced apart array along the locus of the thread. Each thread segment, except the first segment 52, is bounded at each end by a planar surface 53. Each of

25 the planar surfaces 53 is inclined to the longitudinal axis of the closure 10 so that it faces away from the top 15. Each planar surface 53 is also inclined relative to a notional radial plane extending from the axis of the closure 10 to the planar surface 53 in question such that

30 the minimum included angle between the planar surface 53 and the skirt 16 is acute and is less than the angle that a notional radial plane makes with the skirt 16.

The first thread segment 52 is formed with a planar surface 53 on its trailing edge, however it is formed with

35 a point 54 on its leading edge to assist in mating the

thread on the closure 10 with a corresponding thread on the neck of the container 29.

The thread segments 51 in each turn of the thread are aligned as are the spaces between them. A groove 43 is 5 formed on the inside surface of the skirt 16 in each of the aligned spaces between adjacent thread segments 51. The grooves 43 serve to assist in venting gas from a carbonated beverage container as the closure 10 is unscrewed.

10 The end faces of each of the rib segments 19 are each angled as has been described in respect of thread segments. This reduces the likelihood of the ends of the rib segments 19 being damaged as the closure 10 is ejected from a mould.

15 The closure 10 is moulded on a mould core which defines, inter alia, the inside surface of the skirt 16, the thread segments 51 and the grooves 43. It has been found that by forming the thread segments 51 with planar surfaces 53, damage to the thread segments 51 upon 20 the closure 10 being ejected off the mould core has been significantly reduced as compared with forming each of the thread segments with a pointed end similar to point 54.

Fig. 12 depicts that part of a mould 44 used to mould the rib segments 19. It can be seen that the mould 25 defines a recess 45 corresponding in cross-sectional shape to the desired slope of the rib segments 19 and is divided into an outer first surface 47 and an inner second surface 48. The first surface 47 is contiguous with a cylindrical surface 49 of the mould which defines the inside surface 30 of the band 11. This first surface 47 is inclined to a plane normal the axis of the mould by an angle of 20°. The second surface 48 lies in the plane normal to the axis of the mould.

It will be appreciated by persons skilled in the art 35 that numerous variations and/or modifications may be made

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to the invention as shown in the specific embodiments without departing from the spirit or scope of the invention as broadly described. The present embodiments are, therefore, to be considered in all respects as 5 illustrative and not restrictive.

## CLAIMS:

1. A closure suitable for mounting onto a container having closure retention means on the neck of the container, said closure comprising a top portion and a skirt portion depending from the underside of the top portion, which skirt portion has closure retention means complementary to the closure retention means on the container, a band portion joined to the free edge of the skirt through a plurality of frangible bridges, the band portion comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to provide a lip to engage under a retaining flange extending outwardly from the neck of the container below the closure retention means thereon, characterised in that the combined length of the rib segments being equal to at least 50% of the internal circumference of the band portion and being separated from each other by a gap, the rib segments each having an upper side facing generally towards the top portion of the closure and an under side facing generally away from the top portion, the inner surface of the band portion having a plurality of spaced apart radially inward extending projections disposed between the underside of the rib segments and a free edge of the band portion, and the outer surface of the band portion having a plurality of longitudinally extending areas of localised thickening spaced apart on said outer surface, said areas of localised thickening separated from each other by areas that are not so thickened such that the longitudinal stiffness of the body portion is enhanced while still permitting it to move radially outward as the band portion is moved over the retaining flange on the container.
2. The closure as claimed in claim 1 characterised in that the upper side of the rib comprises a first surface contiguous with the body portion of the band, which surface slopes inwardly and downwardly away from the top portion, and a second surface which extends radially outward from the inner terminus of the first surface and has a slope angle substantially normal to the skirt portion of the closure.
3. The closure as claimed in claim 2 characterised in that at least some of the second surfaces of the upper side of the segmented ribs are planar.
4. The closure as claimed in any one of the preceding claims characterised in that the rib segments are substantially evenly spread around the inside circumference of the band.



5. The closure as claimed in any one of the preceding claims characterised in that the rib segments constitute at least 65% of the internal circumference of the band.
6. The closure as claimed in claim 5 characterised in that the rib segments constitute at least 80% of the internal circumference of the band.
7. The closure as claimed in any one of the preceding claims characterised in that the rib comprises a series of rib segments separated by a short gap and wherein alternate radially inward extending projections are disposed between and below the gaps.
10. The closure as claimed in claim 7 and further characterised in that radially inward extending projections extend to substantially the centre of the underside of the rib segments.
15. The closure as claimed in any one of the preceding claims characterised in that areas of localised thickening are of a thickness sufficient that they project radially beyond the circumference of the remainder of the closure.
20. The closure as claimed in any one of the preceding claims characterised in that the closure is formed with means of sealingly engaging with the container to prevent leakage therefrom and wherein means for sealingly engaging the closure with the container comprises an annular sealing rib which projects downwardly from an underside of the top portion of the closure, the rib including a first portion having a substantially cylindrical inner surface, the first portion being contiguous with the top and lying adjacent to the skirt of the closure and a second, frusto-conical, portion contiguous with an end of the first portion distal to the top and extending radially inwardly to terminate in a circular free edge, the first portion having an internal diameter at least equal to an external diameter of the neck of the container to which the closure is to be attached such that during engagement of the closure with the neck, the second, frusto-conical, portion will be engaged by a free end of the neck and folded back against the substantially cylindrical inner surface of the first portion of the rib to form a gas-tight seal between at least an outer surface of the neck of the container and the closure.
30. The closure as claimed in any one of the preceding claims characterised in that the complementary closure retention means is a screw thread.
35. The closure as claimed in any one of the preceding claims characterised in that the complementary closure retention means is a screw thread.



12. The closure as claimed in claim 11 characterised in that the thread on the internal surface of the skirt is formed of a series of thread segments arranged, starting from a first thread segment distal to the top, along a helical thread locus.

5 13. A closure as claimed in claim 12 characterised in that each of the thread segments, except the first, is formed with two substantially planar end surfaces which are each inclined to the axis of the closure and face in a direction downwardly and away from the top of the closure.

10 14. A closure as claimed in claim 13 characterised in that each of the substantially planar ends of the thread segments are also inclined to a notional radial plane extending from the longitudinal axis of the closure to the end of the respective thread segment.

15 15. The closure as claimed in any one of claims 12-14 characterised in that the spaces between the thread segments in adjacent turns of the thread are aligned.

16. The closure as claimed in claim 15 characterised in that a groove is provided on the inside surface of the skirt of the closure extending longitudinally thereof through at least one of the array of aligned spaces.

20 17. The closure as claimed in claim 11 characterised in that the closure has a substantially cylindrical skirt carrying on its outside surface a series of fine vertical ribs terminating at the lower edge of the skirt in a narrow circumferential rib; the frangible bridges are considerably thinner in their radial dimensions than the skirt and the inner surface of the bridges lie flush with the respective radially inner surfaces of the skirt and the band; and the 25 radially outer surface of the band is a slightly smaller diameter than the skirt except in areas of local thickening which project radially outwardly beyond the radial extent of the skirt.

18. The closure as claimed in claim 11 characterised in that the inside 30 surface of the skirt is generally cylindrical with a helical array of thread segments projecting radially inwardly of that surface, the thread segments being separated from one another by axially aligned spaces; the inside of the band is defined by a smooth upper cylindrical surface above the rib of the same diameter as the inside surface of the skirt; the rib is formed of the rib segments evenly arranged about the inside circumference of the band in 35 axial alignment with the thread segments on the inside surface of the skirt and with the spaces between the rib segments in axial alignment with the



spaces between the thread segments; and the inside surface of the band below the rib being inclined downwardly and outwardly so that the band is a little thinner at its lower end than it is at its upper end, this surface carries an array of projections which are axially aligned and of a radial thickness

5 less than that of the rib segments, alternate ones of the projections abut at their upper ends against the mid-point of one of the rib segments and the other projections are each aligned with one of the spaces between the rib segments.

19. A tamper evident closure suitable for mounting onto a container having closure retention means on the neck of the container, said closure comprising a top portion, a skirt portion depending from the top portion, and a tamper evident band portion extending from the skirt portion by connection through frangible bridges, the band comprising a generally cylindrical body portion and a segmented rib extending inwardly of the body portion and adapted to provide a lip having an inner free edge to engage under a retaining flange extending outwardly from the neck of the container below the closure retention means thereon, characterised in that the combined length of the segmented ribs being equal to at least 50% of the internal circumference of the band and the segmented ribs being separated from each other by a gap, the rib segments each having an upper side facing generally towards the top portion of the closure and an under side facing generally away from the top portion, the inner surface of the band having a plurality of radially inward projections extending from above the free edge of band and not extending beyond the inner free edge of the lip.

10 20. The tamper evident closure of claim 19 characterised in that the upper side of the rib comprises a first surface contiguous with the body portion of the band, which surface slopes inwardly and downwardly away from the top portion, and a second surface which extends radially outward from the inner terminus of the first surface and has a slope angle substantially normal to the skirt portion of the closure.

15 21. The tamper evident closure of claim 20 characterised in that at least some of the second surfaces of the upper side of the segmented ribs are planar.

20 22. The tamper evident closure of any one of claims 19-21 characterised in that the rib segments are substantially evenly spread around the inside circumference of the band.



23. The tamper evident closure of any one of claims 19-22 characterised in that the rib segments constitute at least 65% of the internal circumference of the band.

24. The tamper evident closure of claim 23 characterised in that the rib segments constitute at least 80% of the internal circumference of the band.

5 25. The tamper evident closure of any one of claims 19-24 characterised in that the rib comprises a series of rib segments separated by a short gap and wherein alternate radially inward extending projections are disposed between and below the gaps.

10 26. The tamper evident closure of claim 25 and further characterised in that radially inward extending projections extend to substantially the centre of the underside of the rib segments.

27. The tamper evident closure of any one of claims 19-26 characterised in that the closure is formed with means of sealingly engaging with the

15 15 container to prevent leakage therefrom and wherein means for sealingly engaging the closure with the container comprises an annular sealing rib which projects downwardly from an underside of the top portion of the closure, the rib including a first portion having a substantially cylindrical inner surface, the first portion being contiguous with the top and lying adjacent to the skirt of the closure and a second, frusto-conical, portion

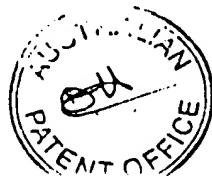
20 contiguous with an end of the first portion distal to the top and extending radially inwardly to terminate in a circular free edge, the first portion having an internal diameter at least equal to an external diameter of the neck of the container to which the closure is to be attached such that during engagement

25 of the closure with the neck, the second frusto-conical portion will be engaged by a free end of the neck and folded back against the substantially cylindrical inner surface of the first portion of the rib to form a gas-tight seal between at least an outer surface of the neck of the container and the closure.

30 28. The tamper evident closure of any one of claims 19-27 characterised in that the closure retention means is a screw thread.

29. The tamper evident closure of any one of claims 19-28 and further characterised in that outer surface of the band portion has means for imparting longitudinal rigidity to the band portion while still permitting the

35 band to extend radially outward as the band portion is moved over the closure retention means on the container.



30. The tamper evident closure of any one of claims 19-29 wherein the closure is one piece.

31. A closure substantially as described with reference to the accompanying drawings.



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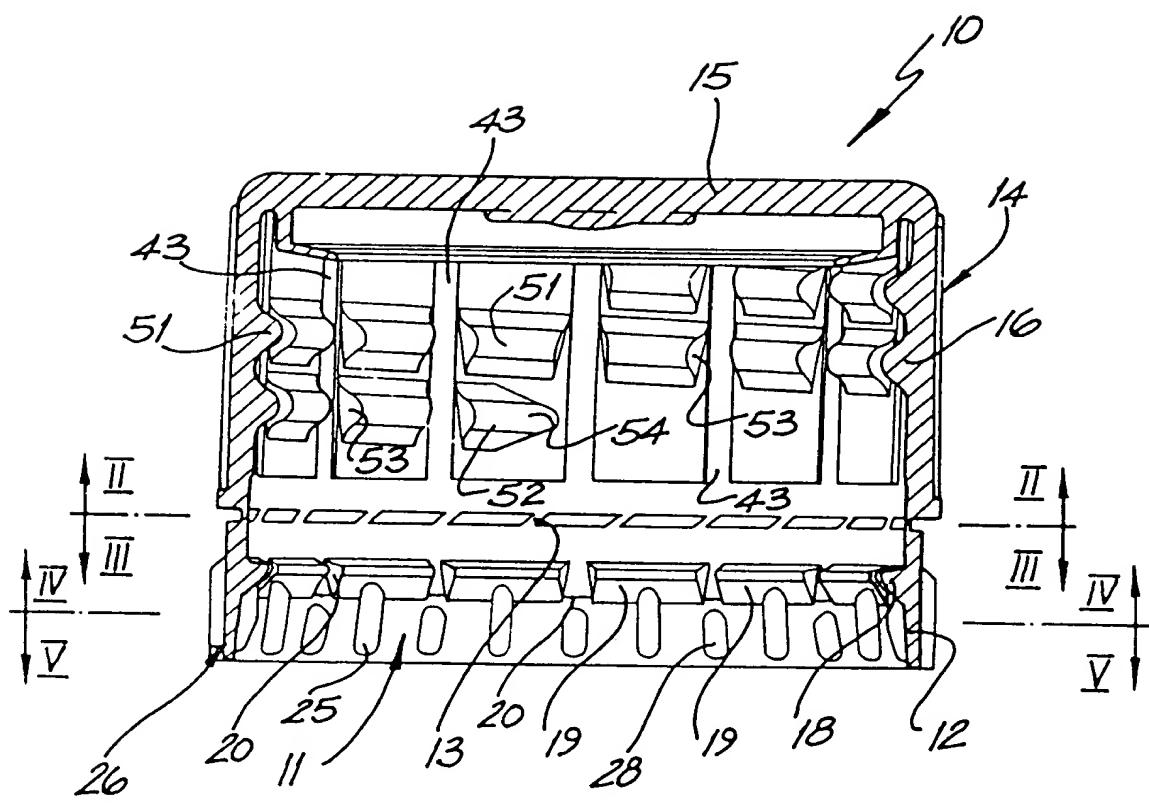


FIG. 1

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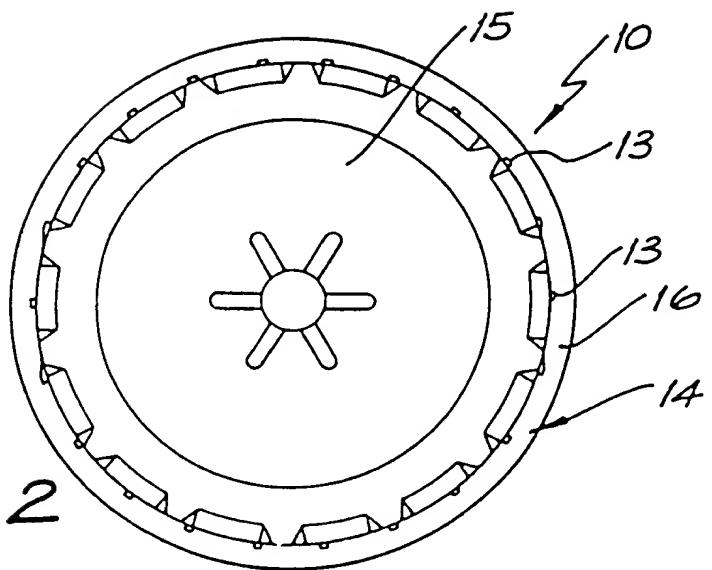


FIG. 2

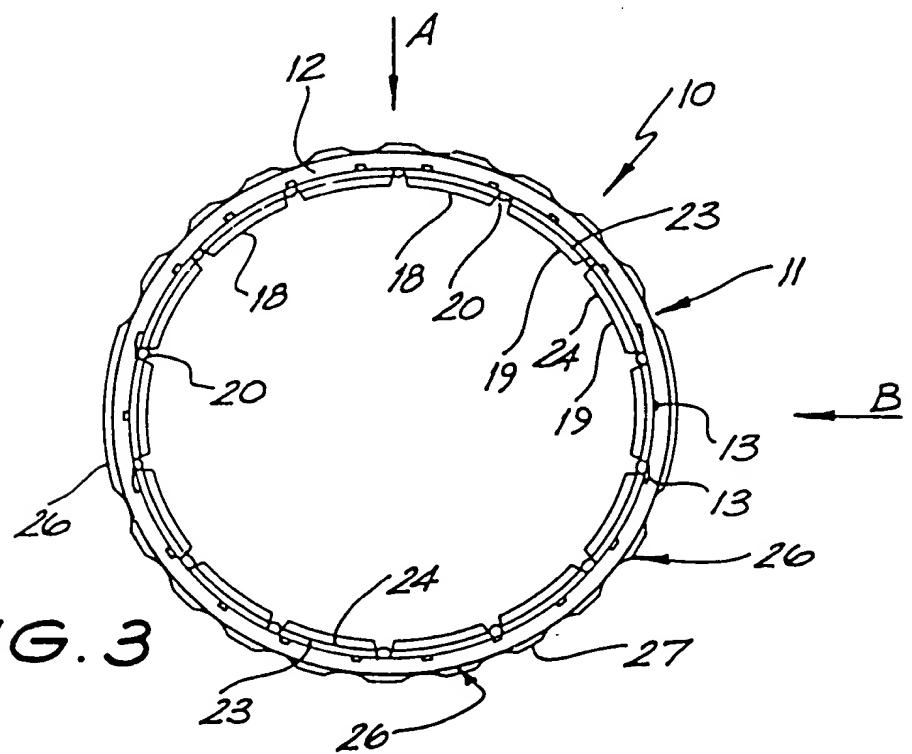


FIG. 3

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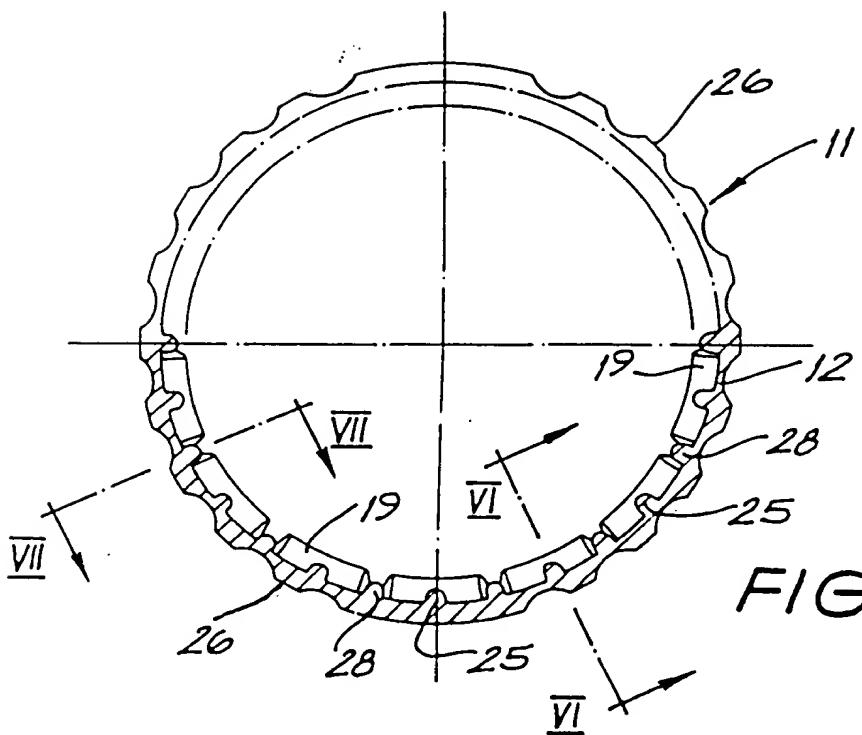


FIG. 4

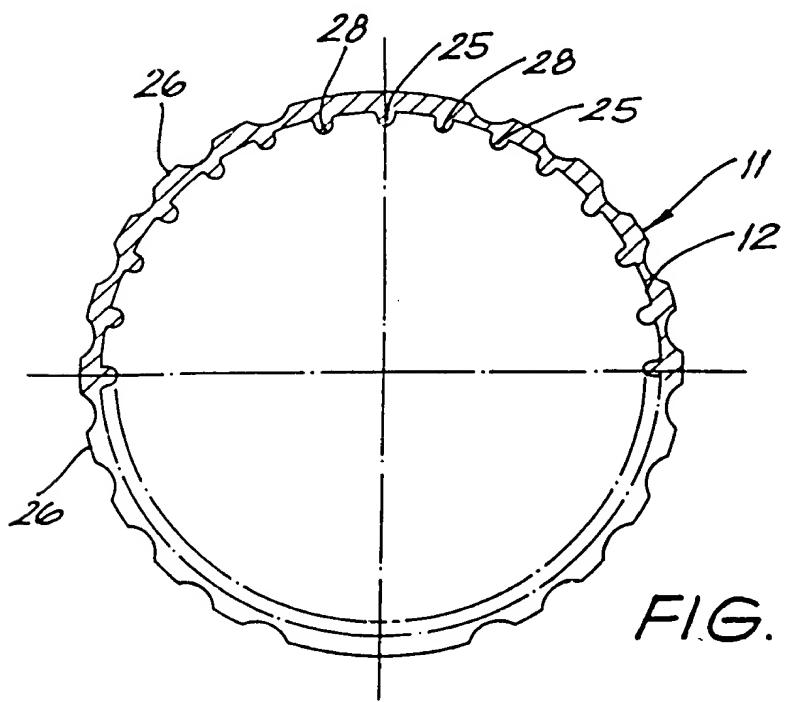


FIG. 5

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FIG. 7

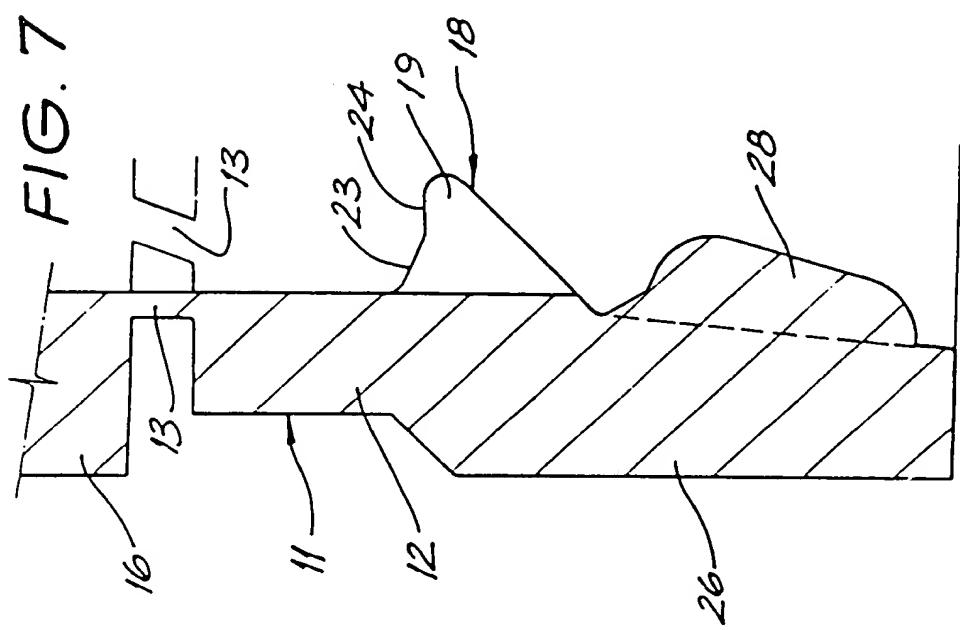
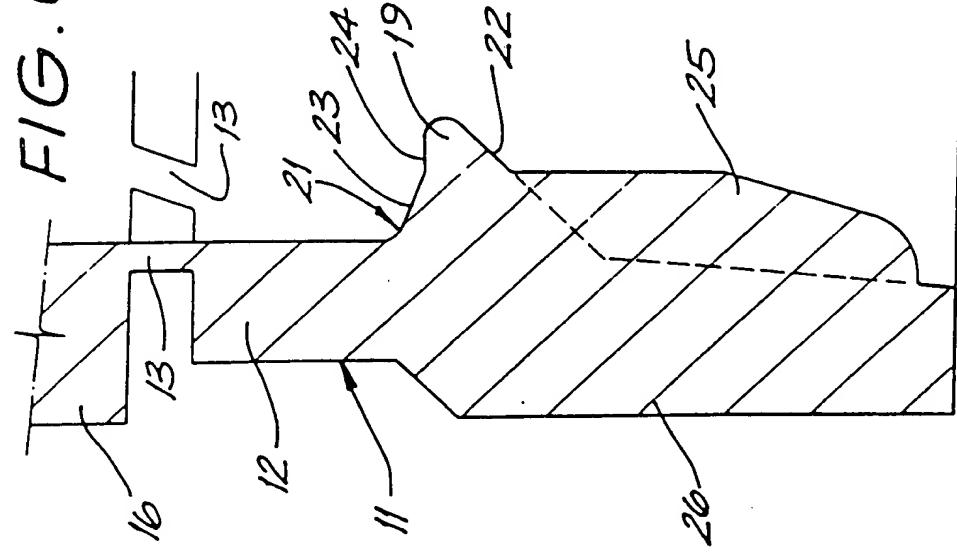
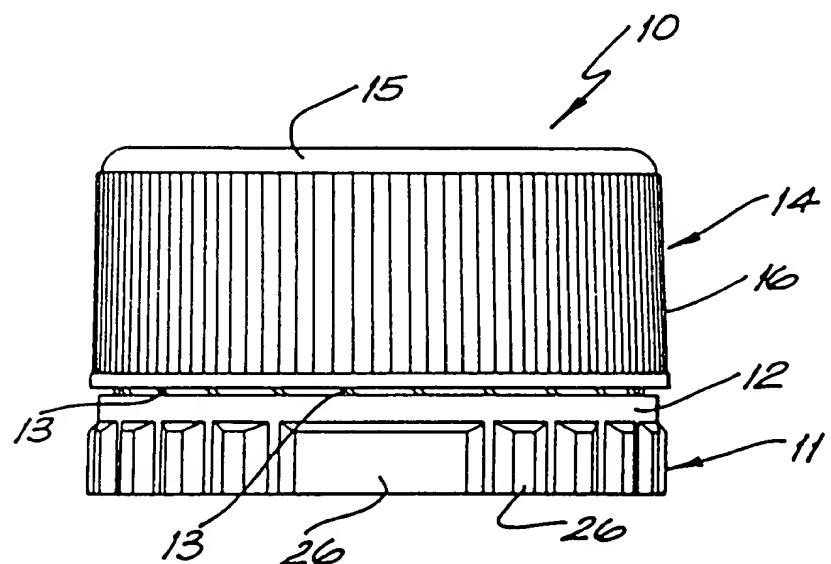
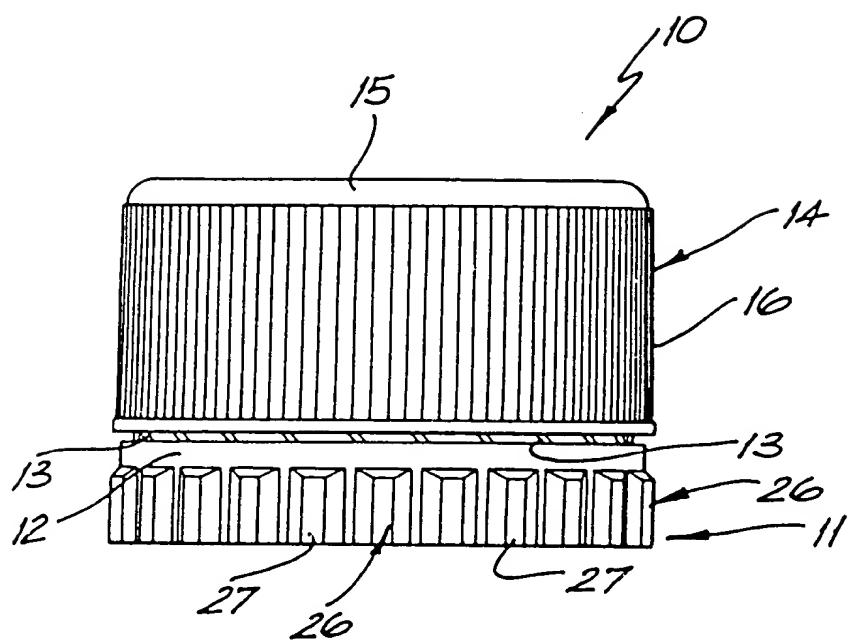


FIG. 6



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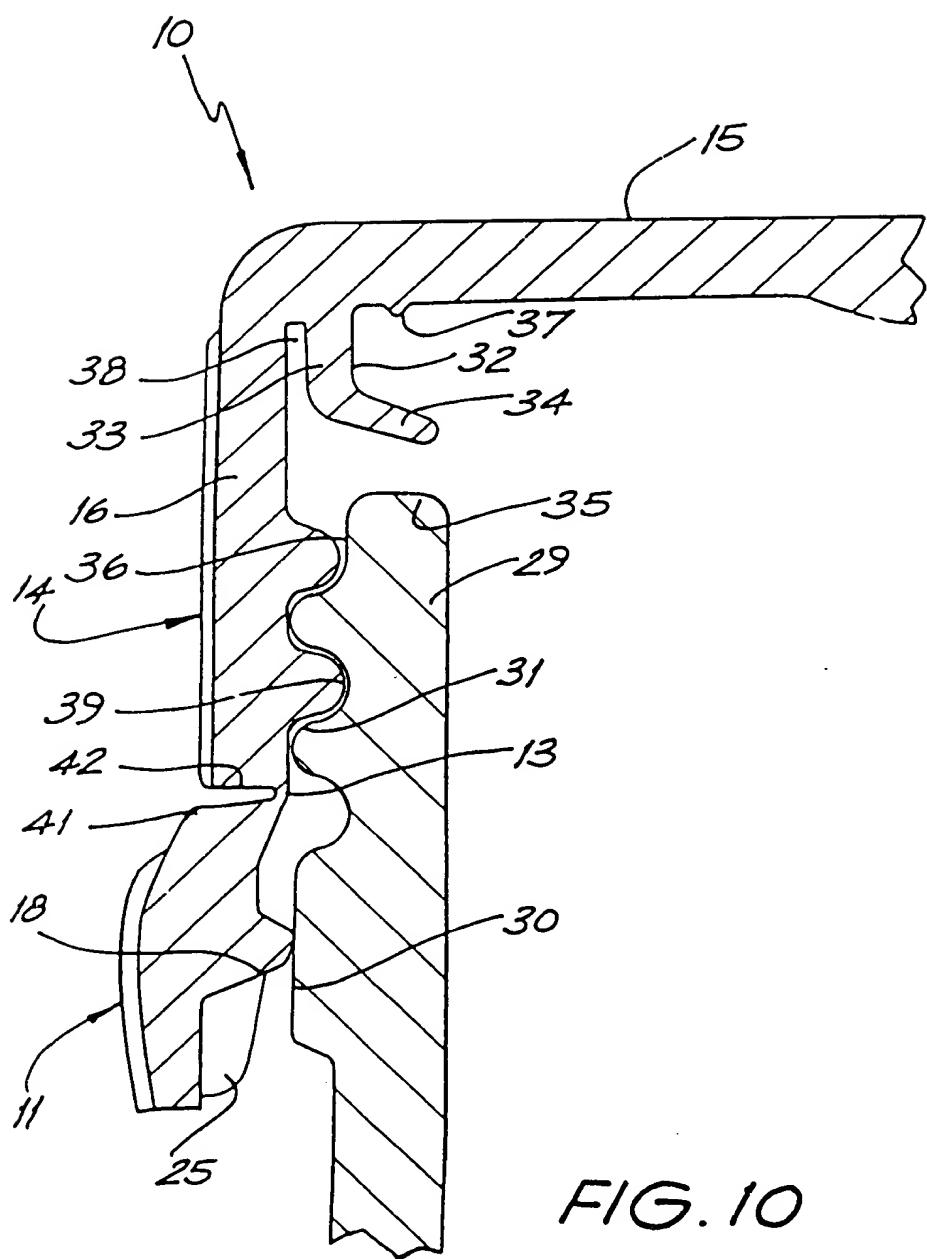


FIG. 10

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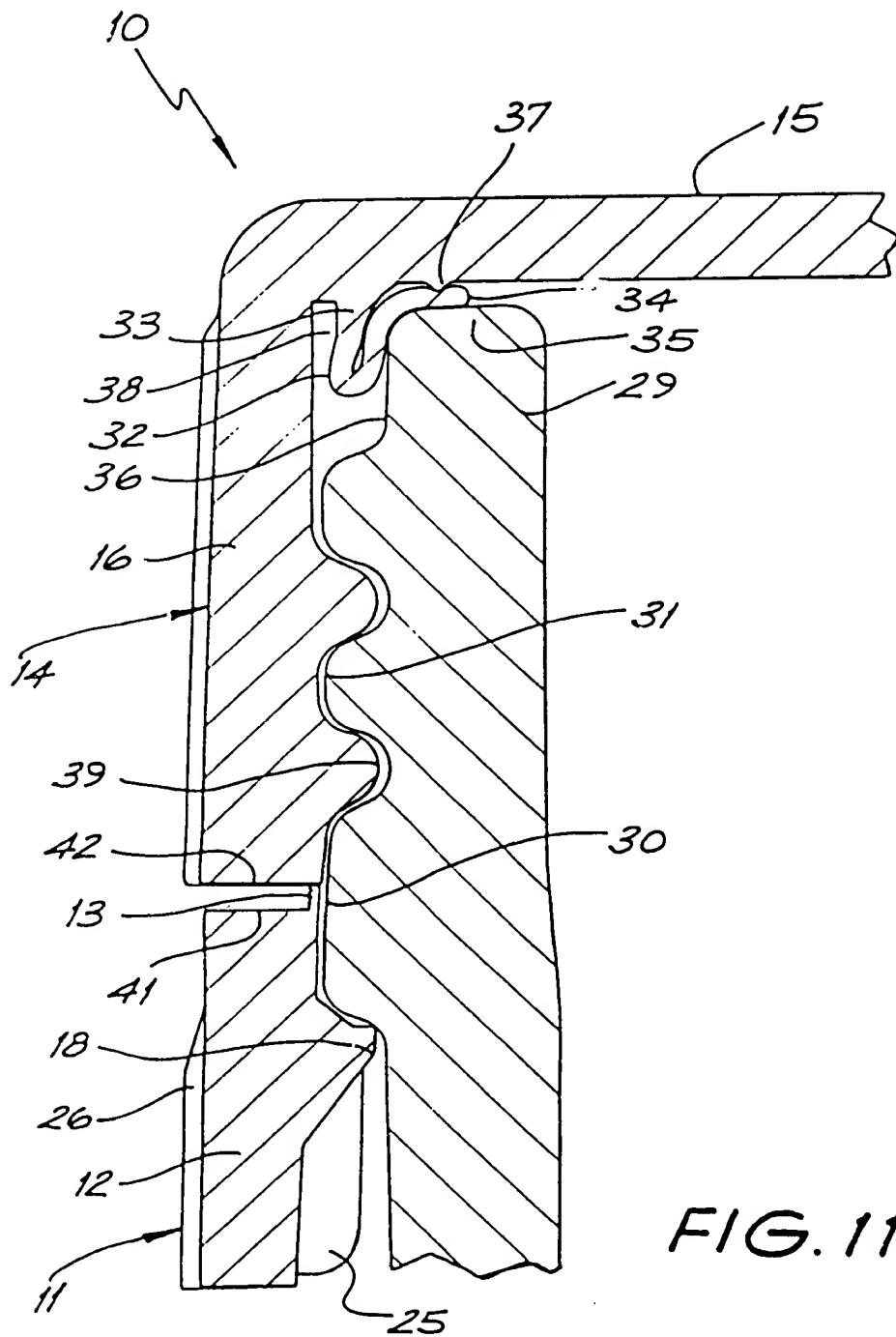


FIG. 11

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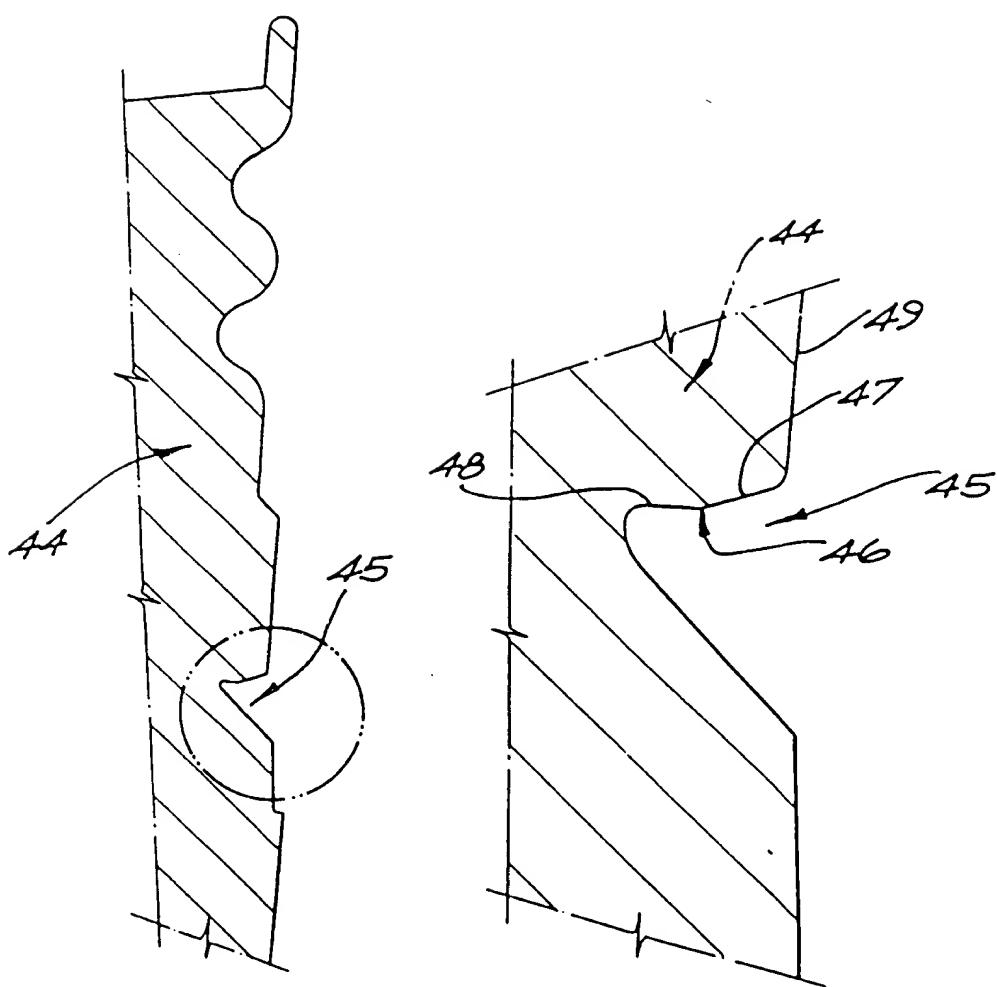


FIG.12

**A. CLASSIFICATION OF SUBJECT MATTER**  
Int. Cl. 5 B65D 41/34, 55/02

According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
IPC: B65D 41/34, 55/02, 55/06, 55/08

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched  
AU: IPC as above

Electronic data base consulted during the international search (name of data base, and where practicable, search terms used)  
DERWENT: Tamper and Thread

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to Claim No.
X Y	DE,A,3912137 (JACOB BERG GmbH & Co. KG) 18 October 1990 (18.10.90) Figures 1 to 5	1,4-11,13-21 12
X Y	EP,A,0370272 (JACOB BERG GmbH & Co. KG) 30 May 1990 (30.05.90) Figures 1 and 2	1,4-11,13-21 12
X	EP,A,0460557 (CROWN CORK AG) 11 December 1991 (11.12.91) Figures 2,3,4 and 5	1,4-8,20

Further documents are listed  
in the continuation of Box C.

See patent family annex.

\* Special categories of cited documents :

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

- "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- "&" document member of the same patent family

Date of the actual completion of the international search

5 October 1993 (05.10.93)

Date of mailing of the international search report

15 OCT 1993 (15.10.93)

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C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate of the relevant passages	Relevant to Claim No.
X	AU,A,21712/88 (METAL CLOSURES LIMITED) 9 March 1989 (09.03.89) Figures 1,2,3 and 9 to 12	1,4-7,11,20
X	EP,A,C299017 (WEIDMER W. PLASTIK) 18 January 1989 (18.01.89) Abstract	1,4-10,20
Y	AU,A,37737/89 (M.K. PLASTICS PTY LIMITED) 12 January 1990 (12.01.90) Whole document	12
X	US,A,5050753 (H-C INDUSTRIES, INC) 24 September 1991 (24.09.91) Figure 1	21

## Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international search report has not established in respect of certain claims under Article 17(2)(a) for the following reasons:

1.  Claims Nos.: because they relate to subject matter not required to be searched by this Authority, namely:
  
2.  Claim Nos.: because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
  
3.  Claims Nos.: because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

## Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

See Supplementary Sheet

1.  As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2.  As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3.  As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
  
4.  No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

## Remark on Protest

The additional search fees were accompanied by the applicant's protest.  
No protest accompanied the payment of additional search fees.

This Annex lists the known "A" publication level patent family members relating to the patent documents cited in the above-mentioned international search report. The Australian Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent Document Cited in Search Report		Patent Family Member					
DE 3912137						10158	
EP 370272	DE 3839351	US 4997097					
EP 460557	AT 91264 EP 460557	DE 58904871	EP 371920				
AU 21712/88	CA 1308061 DK 4895/88 IL 87617 NZ 226007	CN 1031683 EP 306259 JP 1070364 US 4899898	CN 1019782 GB 8720683 NO 883906 ZA 8806537				
EP 299017	AT 67979 CN 1009724 JP 1502656	CH 672109 DE 3865258 US 4913300	CN 88100538 EP 299017 WO 88/05754				
AU 37737/89	BR 8907495 EP 481981 HU 56782 NO 905371	CA 1322187 FI 906178 HU 207485 NZ 229579	DK 2984/90 HU 894027 JP 4506649 WO 89/12584				
US 5050753	AU 85001/91 EP 496873 NO 921626	BR 9105869 JP 5503679 WO 92/03349	CA 2071532 MX 9100823 ZA 9106666				
END OF ANNEX							